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D119-646-243

Job Sheet 187552



Part No: D119-646-243

Job Qty: 1 ea

Part Name: AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible - LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 1/25/19

Created By: Jesse White

Type: Stock

Description:

Note: IIN-D119-646 REV D, D3905-045 REV.F IPP RevA: New issue DD verified by: EC IPP REV.B 12.11.05
(DEOD3905-B-1)(ecn 12-675) DD verf: JLM IPP REV: C 13.03.20 per chg003 ECN13-534 DD verf: JLM IPP
REV: D 15.01.19 AS PER ECN-14-628 DD verf: JLM IPP REV: E 16.11.02 chg as per D3905 revD (DEO) DD
verf: JLM IPP REV: F 17.05.19 as per dwg D3905 rev.e DD verf: JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/25/19	1/25/19	0.00	0.00	Start Up Skid tubes-1		MKG
110	Skid tubes	1 pcs	1/25/19	1/25/19	0.00	2.07	Skid tubes-1		3/1/19
120	HandFinish	1 pcs	1/25/19	1/25/19	0.00	1.05	HandFinish1		D.R 18/12/12
130	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC7-1		MKG
150	Skid tubes	1 pcs	1/25/19	1/25/19	0.00	2.07	Skid tubes-1		MKG
155	CNC Bend Skid tubes	1 pcs	1/25/19	1/25/19	0.00	1.20	CNC Bend Skid tube		MKG
165	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		BE
180	Skid tubes	1 pcs	1/25/19	1/25/19	0.00	2.07	Skid tubes-1		J.M.TF
190	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		BE
200	CNC Bend Skid tubes	1 pcs	1/25/19	1/25/19	0.00	1.20	CNC Bend Skid tube		MKG
210	Skid tubes	1 pcs	1/25/19	1/25/19	0.00	1.41	Skid tubes-1		TE
220	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		BE
224	Skid tubes	1 pcs	1/25/19	1/25/19	0.00	3.70	Skid tubes-1		BE TE DD
225	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		3PL
226	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC10		3PL
227	HandFinish	1 pcs	1/25/19	1/25/19	0.00	1.05	HandFinish2		MAY 29 2019
240	SprayPaint	1 pcs	1/25/19	1/25/19	0.00	0.56	Spray Paint		RD 19-06-23
242	Outsource	1 pcs	1/25/19	1/25/19			ATE003-VC	5	
245	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC14		BEB 19-06-26
250	HandFinish	1 pcs	1/25/19	1/25/19	0.00	1.05	HandFinish4		BEB 19-06-26
260	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		JUN 26 2019
270	HandFinish	1 pcs	1/25/19	1/25/19	0.00	1.49	HandFinish4		BEB 19-06-26
280	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		Ym 19-06-26
285	HandFinish	1 pcs	1/25/19	1/25/19	0.00	1.05	HandFinish3		BEB 19-
286	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC5		SEP 04 2019
288	DC	1 pcs	1/25/19	1/25/19	0.00	0.00	DC		SEP 18 2019
290	Packaging	1 pcs	1/25/19	1/25/19	0.00	0.00	Packaging3-1		SEP 18 2019
300	QC21-FG	1 Ea	1/25/19	1/25/19	0.00	0.00	QC21		SEP 18 2019

Part Op 110 - 1- Inspect Matl D2500-1-190 for damage 2- Ensure squareness of ends

Plex 12/7/18 11:42 AM dart.white.jesse

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No.: _____		DISPOSITION Rework ☐ Scrap ☐ DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____		Sequ _____		Container No: S136921  Part: D119-646-243 Job No: 187552 Serial No/Batch: S136921 Revision: D,F Inspector: _____ Exp Date: _____ Instructions: FAA STC SR02024SE 15/10/28 TC STC LoA P-09-0407-RDIMS	
Description Work Order		Position		MRB (QSI042)	
				Completed By	
				Lead hand / Supervisor 	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FACTORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			

S136921x1xLH

Descriptions: 120 - Chemical Conversion Coat per QSI005 4.1

130 - QC7-Inspect Chemical Conversion Coat

150 - 1- Install drill Jlg DT9480 drill all x-bolt spacer holes using 3/16 drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Scribe batch # inside aft end of tube

155 - 1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end. 2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

165 - QC5- Inspect part completeness to step on W/O

180 - 1- Verify dimension of bend as per dwg D3905 2- Buff out marks left from bending. 3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, open to finished size 4- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E) ***DO NOT OPEN FWD SADDLE HOLES*** 5- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail G open to finished size 6- Deburr, blow out chips from inside of tube 7- Bond web in place as per Dwg D3905 & QSI 015. A/R Sikaflex-291 138984 Sikaflex expire

date: 19.01.03 Start: 3:30pm Time: _____ Finish: 3:45pm Time: _____ ***** (Adhere for 12 hours)*****

190 - QC5- Inspect part completeness to step on W/O

200 - 1- Bend Fwd end of tube using bender 1 and bend prog. D3905 & Folio -04 Fwd. Use bending aid DT9544 ensure proper positioning 2- Cut Fwd end of tube as per dwg. ***VERIFY MEASUREMENT BEFORE CUTTING***

210 - 1- Buff out marks left from bending 2- Drill Fwd cap holes using DT8215. 3- Open Fwd saddle holes to finished size as per dwg 4- Drill Fwd x-bolt hole and open to finished size using DT9816 5- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 6- Drill towing hole using DT10047 locate from FWD saddle hole and open to finished size. 7- C-sink FWD cap hole as per detail "C" 10- Deburr, blow out chips from inside of tube.

220 - QC5- Inspect part completeness to step on W/O

224 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1- Countersink x-bolt holes as per dwg 2- Remove alodine prepare for welding 3- Insert x-bolt spacers 4- Weld x-bolt spacer as per dwg A/R Alum rod Batch: 138984 5- Grind welds flush as per dwg 6- Counter bore x-bolt holes as per dwg 7- Deburr 8- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skid tube batch#.

225 - QC5- Inspect part completeness to step on W/O TEST FIT USING FIXTURE DT10091.

226 - QC10- Inspect visual per QSI004- ground welds

227 - Pressure Wash per QSI005 4.3

240 - Spray Painting per QSI005 4.2 *****AS PER DEO DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 5189315 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 5189315

245 - QC14- Inspect Spray Paint

250 - Assemble as per dwg 1- Install inserts as per Dwg D3905.

260 - QC5- Inspect part completeness to step on W/O

270 - 1- Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 2- Install plugs assembly as per dwg. 3- Inspect for foreign objects as per QSI 024 4- Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 5- Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____

6- Install (2) D5101-041 and (1) D5101-047 as per dwg by using DT10117 7- INSTALL PLUGS

280 - QC5- Inspect part completeness to step on W/O

285 - Wing Walk as per dwg QSI005 4.4 Batch _____

286 - QC5- Inspect part completeness to step on W/O

288 - Document Control Photocopy bluefile & type labels per PPP D119-646-243 CHG 006

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - 1" Beam Tube 4"	1 pcs (1 ea)	90-Start up Operation	5112913
D3885-3	Float Web	1 Ea (1 ea)	180-Skidtubes	5096476
D2579	Crossbolt Spacer	2 pcs (2 ea)	224-Skidtubes	5097840
D2855-5	Cap	1 pcs (1 ea)	224-Skidtubes	502078
D3681-1	Spacer	12 Ea (12 ea)	224-Skidtubes	5145873
D3903-1	Spacer	12 pcs (12 ea)	224-Skidtubes	5144956
ALS4-1032-130	Rivnut	10 Ea (10 ea)	250-HandFinish	5057257
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-HandFinish	5174308
AN3C46A	Bolt	4 Ea (4 ea)	270-HandFinish	5095398
AN3C50A	Bolt	4 Ea (4 ea)	270-HandFinish	5109956
AN3C5A	Bolt	12 Ea (12 ea)	270-HandFinish	5192144
AN4C46A	Bolt	3 Ea (3 ea)	270-HandFinish	5100406
D2855-3	Cap	1 pcs (1 ea)	270-HandFinish	5126403
D3411-3	Washer	24 Ea (24 ea)	270-HandFinish	10x 5145921/14.5145923
D3672-1	Washer, Phenolic	2 Ea (2 ea)	270-HandFinish	5164008
D3847-1	Wearpad	1 Ea (1 ea)	270-HandFinish	5142046
D3847-11	Wearpad	1 Ea (1 ea)	270-HandFinish	5136646
D3849-045	Aft Heavy-Duty Wearplate, Float Skid Compatible	1 Ea (1 ea)	270-HandFinish	5156205
D3849-047	Fwd Heavy-Duty Wearplate, Float Skid Compatible	1 Ea (1 ea)	270-HandFinish	5158843
D3904-1	Washer	16 pcs (16 ea)	270-HandFinish	5172882
D5101-041	Crossbolt Spacer Assembly	2 Ea (2 ea)	270-HandFinish	5145324
D5101-047	Crossbolt Spacer Assembly	1 Ea (1 ea)	270-HandFinish	5103114
D5101-3	Insert	6 Ea (6 ea)	270-HandFinish	5144001
D5101-5	Insert	6 Ea (6 ea)	270-HandFinish	5143979
MS21043-3	Nut	8 Ea (8 ea)	270-HandFinish	5099569
MS21043-4	Nut	3 Ea (3 ea)	270-HandFinish	5144565
MS24694-C52	Screw	2 Ea (2 ea)	270-HandFinish	5067269
NAS1149C0332R	Washer	8 Ea (8 ea)	270-HandFinish	5158078
NAS1149D0416J	Washer	3 Ea (3 ea)	270-HandFinish	51131511
D3492-5	Plug	8 Ea (8 ea)	270-HandFinish	5183338
NAS1611-005	O-Ring	8 Ea (8 ea)	270-HandFinish	5127852

12
9/15/20

M.U. 010605

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 180-Skidtubes 224-Skidtubes	D2500-1-190	1	54	0
	D3885-3	1	12	0
	D2579	2	199	0
	D2855-5	1	123	0
	D3681-1	12	132	0
250-HandFinish 270-HandFinish	D3903-1	12	81	0
	ALS4-1032-130	10	10,623	0
	ALS4-1032-225	1	1,280	0
	AN3C46A	4	103	0
	AN3C50A	4	173	0
	AN3C5A	12	1,492	0
	AN4C46A	3	160	0
	D2855-3	1	51	0
	D3411-3	24	42	0
	D3492-5	8	119	0
	D3672-1	2	1,399	0
	D3847-1	1	40	0
	D3847-11	1	10	0
	D3849-045	1	2	0
	D3849-047	1	1	0
	D3904-1	16	56	0
	D5101-041	2	2	0
	D5101-047	1	4	0
	D5101-3	6	9	0
	D5101-5	6	6	0
	MS21043-3	8	866	0
	MS21043-4	3	859	0
	MS24694-C52	2	120	0
	NAS1149C0332R	8	3,012	0
	NAS1149D0416J	3	2,100	0
	NAS1611-005	8	303	0
Part Specifications				
Specifications could not be found.				

Plex 12/7/18 11:42 AM dart.white.jesse

Change Record

PAGE 1 OF 1

Part Number: D119-646-243

Description: REPLACEMENT FLOAT SKIDTUBE w/ TRAINING WEARPLATES

[illegible]

Entered:

Date:

2R Oct 25/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

19-7573

Job:

187552

Part No.

D119-646-243

DISPOSITION

 Rework ☒
 Scrap ☐
 Use-as-is ☐

DEPARTMENT/PROCESS

 Skid-tube ☒
 Machining ☐
 Large Fab ☐

 Cross tube ☐
 Small Fab ☐
 Finishing ☐

 Eng. (Non-AW) ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐

 Engineering ☐
 Water Jet ☐
 Supplier Quality ☐

Date:

JAN 15 2019

Sequence #:

210

QTY Affected:

1

MRB (QSI042)

 MSP
 12 4/19/16

Description Work Order Deviation

Disposition

- TWO HOLES 1/8" DRILLED AT THE WRONG PLACE, 3 1/8" AND 7" FROM FRONT OF SKID TUBE, INSTEAD OF 1 7/8" AND 5 5/8", DRILL JIG WAS IMPROPERLY LINED UP TO THE SKID TUBE.

Fill incorrect holes with weld and grind flush. AIR M/38989

Incorrect holes are small 1/3" away from correct holes. Crossbit + spacers are welded. So welding has no effect on strength.

 DAS
 68
 9-89

Completed By

 BE
 19/05/01

Lead hand / Supervisor

 JW
 19-05-01

QC / QA Coordinator

 68
 9-89

JUN 20 2019

Root Cause

 Operator ☒
 Manufacturing Process ☐
 Equip/Tooling ☐
 Handling/Preservation ☐
 Material ☐
 Product Improvement ☐
 Process Improvement ☐
 Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled

☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☒ Drill Holes
☐ Fit/Function

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up

☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: